

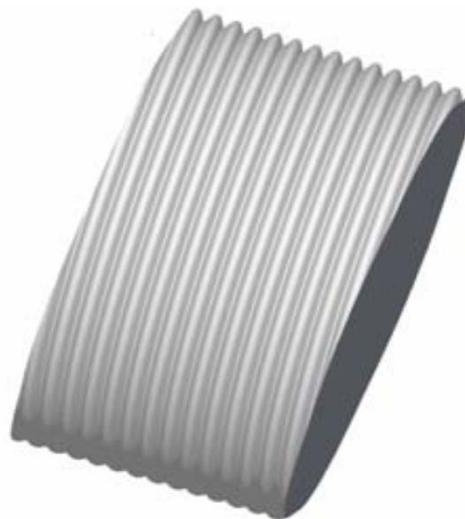
# Cylindrical Thread Rolling Die

A21-010

HSS Cylindrical Thread Rolling  
Die production with conventional  
wheels.

Wheel No. 1 three profiles  
dressed on.

Wheel No. 2 single profile  
dressed on.



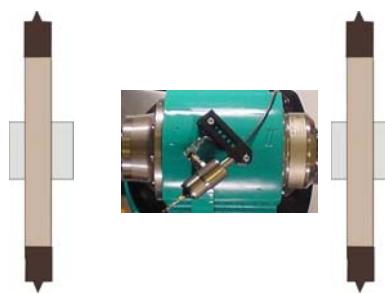
## 1. Cycletime for Production

Workpiece: Ø178 L76 Z310 P1.805 Helix 21° Material HSS								
Operations	Dress	MainThread	Dress	MainThread	Dress	MainThread	Dress	MainThread
Feed [mm/Min]	36	2000	36	2000	36	2000	36	2000
Increments [tot./part.]	0.1/0.01	0.4/0.1	0.2/0.01	0.2/0.01	0.1/0.01	0.03/0.01	0.05/0.01	0.03/0.005
Cutting speed [m/s]	12	45	12	45	12	45	12	45
Used wheels								
Grinding time [s]	1	1	1	1	2	2	2	2
Total cycle time	149 Min 17							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

1	DXF Ø200 C120
2	DXF Ø200 C220



1

2

## 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMACfg

Coolant: Synthetic Oil, pressure 10 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Dressing Unit

Responsible engineer: OP, 25.5.13

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